Tuesday, 11/29/2005 4:38:57 PM

User

Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 25028 : 11086

P.O. Number

This Issue

Prsht Rev.

Written By

Comment

: NIA

: 11/29/2005

S.O. No. : NIA

: NC

: NIA First Issue Previous Run

Checked & Approved By

: NIA

Type : MACHINED PARTS

: Est Rev:B Removed -3

05-11-29 JLM **Drawing Name** : BUSHING

: D31761

Part Number Drawing Number

D3176 REV A

: N/A Project Number : A

Drawing Revision Material

:NIA Due Date : 12/6/2005

Qty:

4 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M303R1000

303 Round Bar 1.0"

1.3020 f(s)



0.3255 f(s)/Unit Total: Comment: Qty.: Material: AISI 303 SS 1.00 round bar Ref: Dart Spec: M303R1.000)

Batch: M18429

05/12/07

2.0

HARDINGE

HARDINGE CNC LATHE SMALL





Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA286 & DWG D3176

2-Debur

2. Mill flats as per Due 03176

INSPECT PARTS AS THEY COME OFF MACHIN

3.0

4.0

QC2

QC8



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



44



736-

Comment: SECOND CHECK

PACKAGING 1 5.0

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: F. P. 14 1 LOS/12/12



Dart Aerospace Ltd

:W/O:	WORK ORDER CHANGES											
DATE	STEP	a .	: :	PRO	CEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No			Ę	PAR #:	Fault Category:		NC	R: Yes	No DQ	A: 🔁	₽ Date: ⊘	5/12/13

Part No:	PAR #:	Fault Ca	tegory:	NCR: Yes (DQA:	⊉ Date: <u>∢</u>	5412/13
		:		QA: N/	C Closed:	Date: _	*
NCR:		WORK OR	DER NON-CONFO	ORMANCE (NCR)	1 <u>4</u>		
DATE STEP	Description of NC	Initial	Corrective Action	Section B	Verification	Approval	Approval

	•			* **	. 124
		Description of NC	Corrective Action Section B	Verification Approval	Approval
DATE	STEP	Section A	Initial Action Description Sign & Date	Section C Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date: User:

Tuesday, 11/29/2005 4:38:57 PM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 25028

Part Number: D31761

Job Number:



Seq.#:

Machine Or Operation:

Description:

6.0

DC

DOCUMENT CONTROL





Comment: DOCUMENT CONTROL

Inspection Level 21

5 n = 05/12/13 (y)



05/12/13

Job Completion



Dart Aerospace Ltd

W/O: ~	aga Luar . Sans . S	The second section of the second section is a second section.	WC	RK ORDER CHANG	ES		***	A second
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NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR))		7 9
	0	Description of NC Corrective Action Section B				Verification	Approval	Approval,
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Bushing	Part Number:	D3176-1
Inspection Dwg: D3176 Rev: A		Page 1 of 1

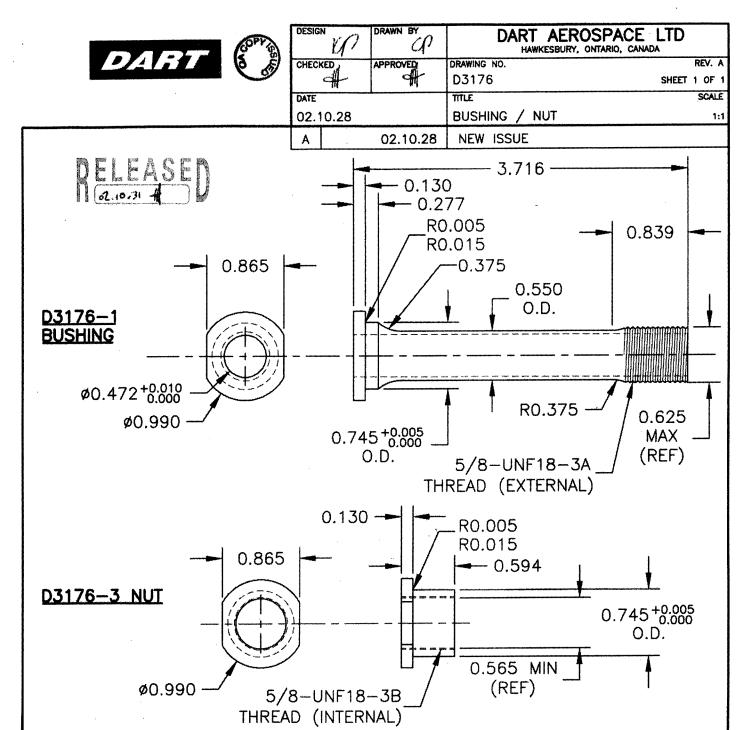
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.990	+/-0.010	\$ 0.990				
Ø0.472	+0.010/-0.000	80.478				
3.716	+/-0.010	3,710)			
0.130	+/-0.010	0.137)			
0.277	+/-0.010	0.287				
0.550	+/-0.010	0.553)			
0.839	+/-0.010	0.830	_			
0.745	+0.005/-0.000	0.747				
0.625	+/-0.010	0.621				
5/8-UNF18-3B	N/A	N/A	-			
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Measured by:	ml	Audited by: J.L	Prototype Approval:	N/A
Date:	05/12/07	Date: 05.12.07	Date:	NhA

Rev	Date	Change	Revised by	Approved
Α	03.11.12	New Issue	KJ/RF	



D3176 - 1/-3

- 1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
- 2) THREADS PER MIL-S-7742
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) FINISH: NONE
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) D3176-1/-3 ARE MATING PARTS

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